

Date: Tuesday, 23/12/2008 1:24:32 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 44314B
 Estimate Number : 11180
 P.O. Number :
 This Issue : 23/12/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 44079
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM

Drawing Name : SADDLE ASSEMBLY
 Part Number : D2282043
 Drawing Number : D2282 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 30/01/2009 Qty: 60 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2281	Jack Saddle
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) Pick: Qty Part Number Description Batch 1. D2281 Saddle 43742.
		SP 09.01.15
2.0	D22827	Tube
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s) Pick: Qty Part Number Description Batch 2 D22827 tube B44157=74, B41891=46.
		SP 09.01.15
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		Comment: LARGE FABRICATION RESOURCE 1
		1-Weld as per D2282-043 Saddle Assembly
		A/R ER316L SS Filling Rod M107051 Dwg Rev: E M106115
		SP 09.01.20 60x
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		1- grind weld flush, take all welding marks out and deburr holes
		SP 09.01.20 M-1 09/01/26 60x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 1:24:32 PM
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Process Sheet

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Drawing Name: SADDLE ASSEMBLY

Job Number: 44314B

Part Number: D2282043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-27 (60)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Counters

Step 1/7 x60

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble RB 94-30

8.0 QC5 INSPECT WORK TO CURRENT STEP



09-01-20

Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

09/09/02/02

60

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/02/02 PD

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-0202

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

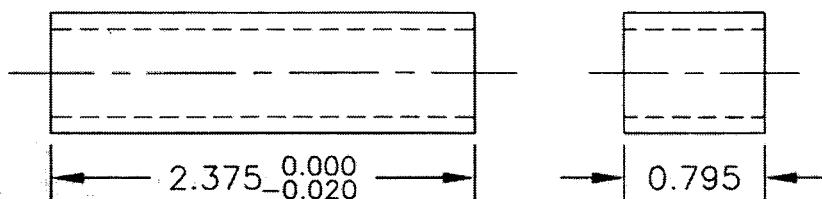
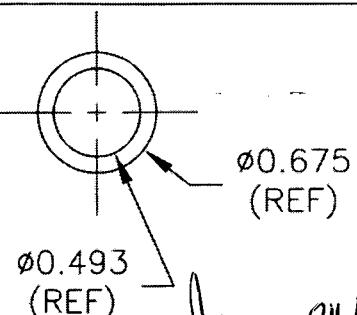
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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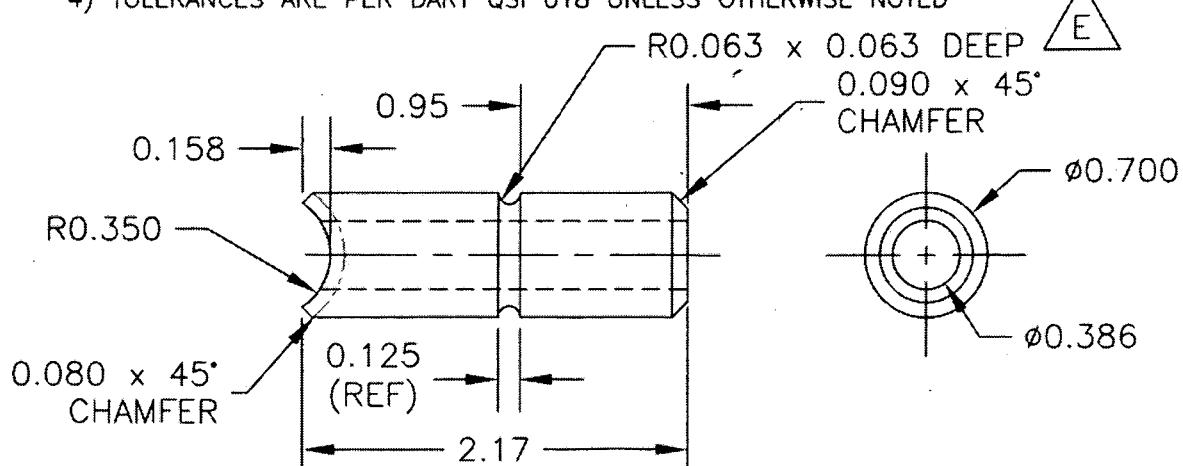
DART

DESIGN BW	DRAWN BY <i>FB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

RELEASED
BS/09/16

D2282-3D2282-7*W044344B*D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2282-5D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

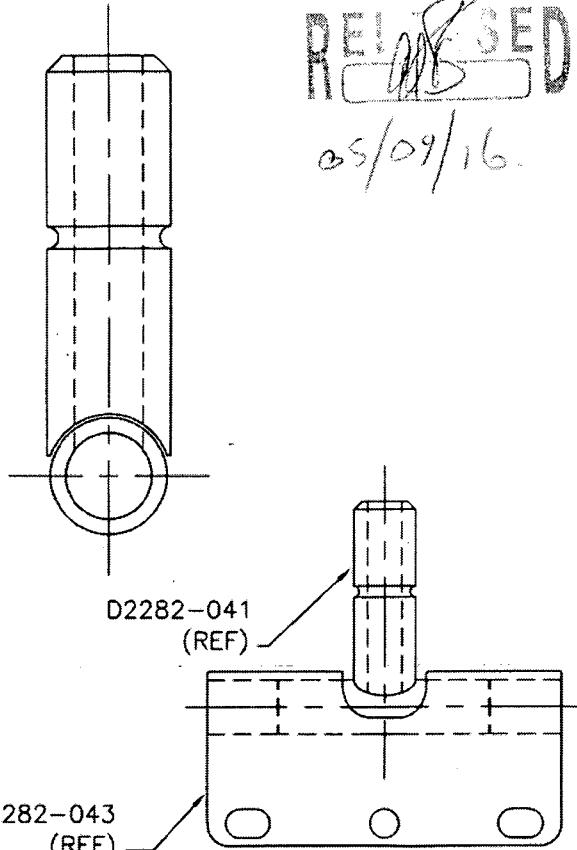
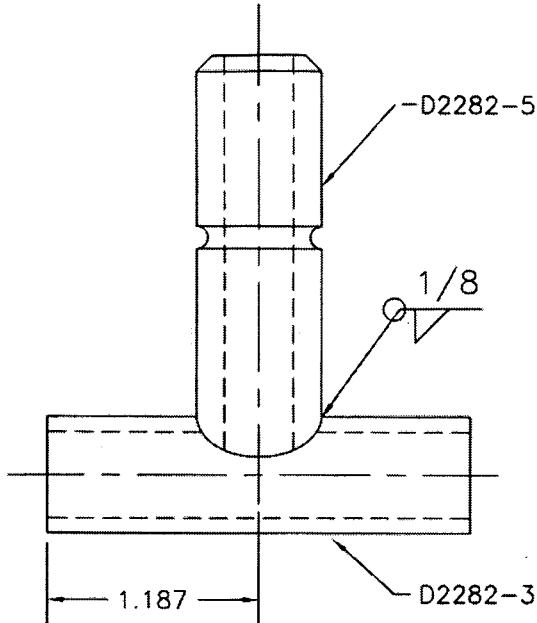
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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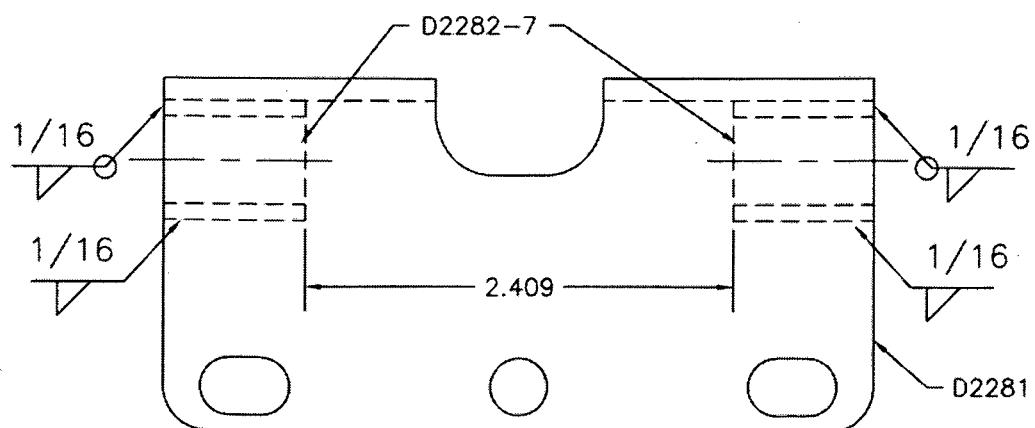
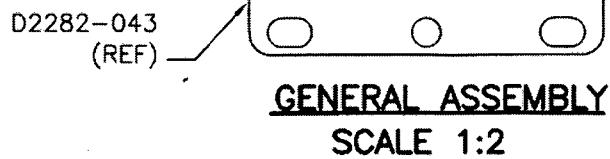
• NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>RP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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